

Date: Tuesday, 4/4/2006 1:27:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ANGLE		
Job Number	: 26496		Part Number	: D21752		
Estimate Number	: 10198		Drawing Number	: D2175 REV. D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/4/2006	S.O. No. : N/A	Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 4/28/2006		
Previous Run	: 2628		Qty:	20	Um:	Each
Written By	: See Comment Below					
Checked & Approved By	: (Signature) 04.04.04					
Comment	: Est E 04.06.09 Reformat KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 9.9162 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: M1/05/09

M 06/05/11

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 12.75" x 2.95" Grain along 2.95"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA083 and Dwg D2175

Stack of 10

Identify as D2175-2

Prog Rev: D
 Dwg Rev: D

M 06/05/11 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE



M 06/05/11 (20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK



6605-13 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:27 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 26496

Part Number: D21752

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

H.M 06/05/24

Deburr Stack

SAD 06/05/15 20

7.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 06/05/23 20

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/25 20

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/05/25 20

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Stock

06/05/25 20

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/26 20

Job Completion



06/05/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26496
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

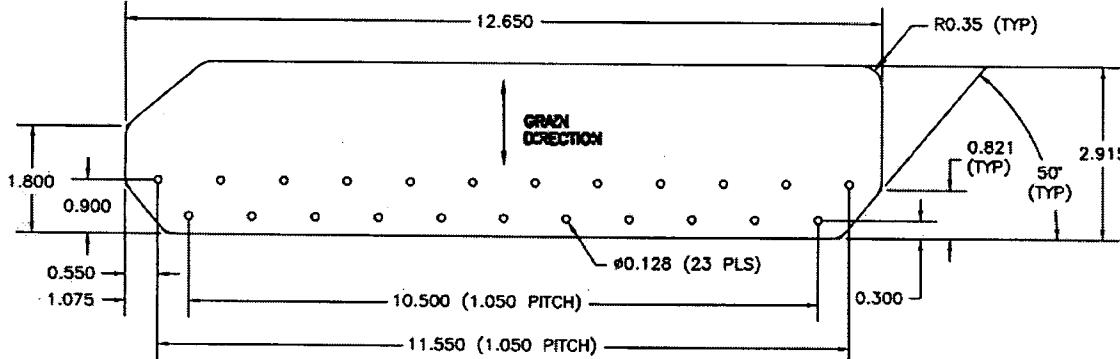
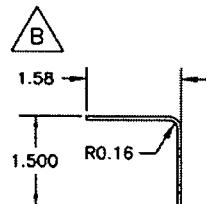
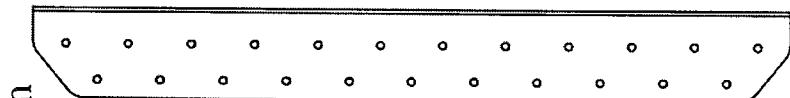
X First Article Prototype

Measured by:	<u>M. M.</u>	Audited by:	<u>Z</u>	Prototype Approval:	N/A
Date:	<u>06/05/11</u>	Date:	<u>06/05/11</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	SGT

DARTCOPY IS
DELETED**DART AEROSPACE LTD**
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO. D2175	
DATE		TITLE	SCALE
04.06.03		95.10.25 NEW ISSUE	
A		96.01.18 CHANGED DIMENSION	
B		00.09.11 UPDATE FINISH SPEC	
C			
D		04.06.03 RE-DESIGN	
			REV. D
			SHEET 1 OF 1
			1:3

**D2175 FLAT PATTERN****D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 2446

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES